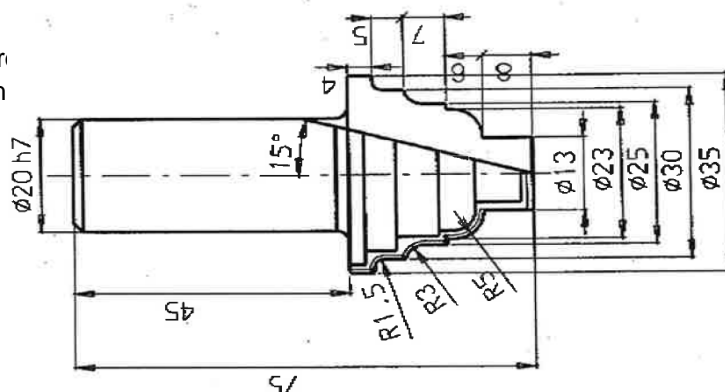


## ShearAngle Profile Tool Ø35 Z2

A16-200

Facegrinding according to bottom angle of 15° and 2° Shearangle. Roughing is done in plunge grinding. The pr being open, pregrinding and finishing can be ground with standard cup wheels.

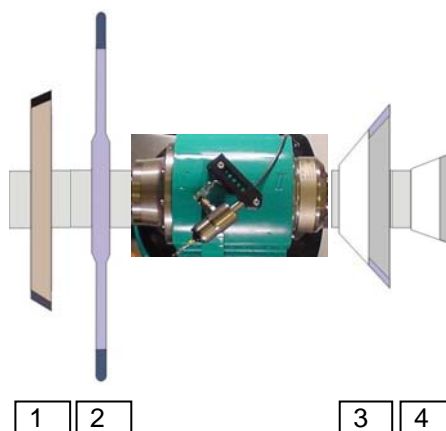


Workpiece: D 35 mm, Z 2, Length 30 mm, ShearAngle 2° Material CARBIDE					
Operations	Probe	Flute 1	Prf Rough	Prf Pgrd	Prf fin
Feed [mm/Min]	2000	70	100	70	100
Power [kW]		3	2	1	1
Cutting feed [m/s]		22	20	22	22
Used wheels		1	2	3	4
Grinding time [s]	30	74	420	93	68
Total cycle time	11 Min 24				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1V1 Ø125 D64
2	14F1 Ø200 D76R1.5
3	12V9 Ø150 D64
4	11V9 Ø100 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG      Coolant: Synthetic Oil, pressure 6 bar  
 Control: Fanuc 310i      Software: Quinto 5  
 Accessories:

Responsible engineer: OP. 3.8.10

[www.schneeberger.ch](http://www.schneeberger.ch)

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